

Date: Wednesday, 26/11/2008 12:46:49 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 43773		
Estimate Number	: 12952		
P.O. Number	:	Part Number	: D32594
This Issue	: 26/11/2008 S.O. No. :	Drawing Number	: D3259 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A1
Previous Run	: 34252	Material	:
Written By	:	Due Date	: 03/12/2008 Qty: 4 Um: Each
Checked & Approved By	: <u>JVD 08.11.26</u>		
Comment	: Est Rev:A New Issue 07-07-19 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S063	2024-T3 .063 sheet
-----	-------------	--------------------



Comment: Qty.: 1.4574 sf(s)/Unit Total: 5.8296 sf(s)
 2024-T3 .063 sheet
 Batch: 109463 B 9-1-19
B 8-12-9

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3259
 Dwg Rev: A1
 Prog Rev: A1

B 9-1-19
B 8-12-9
B 9-1-19
B 8-12-9

(3) B 9-1-19
(5)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

S 08/12/08 (45)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-C Sink Holes as per Dwg D3259

CP 09/01/14 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 26/11/2008 12:46:49 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 43773

Part Number: D32594

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

BRAKE NC

NC BRAKE



(Pb) →

Comment: NC BRAKE

1-Form as per Dwg D3259

SB 09/01/22 (5)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/22 (X5)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



HW 9-1-23

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Pc 9/6/23 (5)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST/81

Pc 9/6/23

(5)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/26

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3259-4 PAR #: 09-005 ~~11A~~ Fault Category: Eng. Dwg. NCR: ☒ Yes ☐ No DQA: 1A Date: 09.01.26
 Resolution: _____ Disposition: _____ QA: N/C Closed: 1A Date: 09/02/09

NCR: <u>43773</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/1/16	# 60	Durain forming operator noticed / found sound Qty (3) Parts cracking Durain Bendin at the 110° Bend.	09.01.16	SCRAP and Destroy and replace Qty (3) B# 109643	09-1-19 09/01/22	09/01/22	09.01.16	09.01.16
		R.C Rad on Dwg is incorrect should be min 0.210"	09.01.19	open PAR to change Rad on Dwg. PAR 09-005	09-02-02	09.01.19	09.01.19	09-02-02

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 43773
Description: Doubler		Part Number: D3259-3/-4
Inspection Dwg: D3259	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.062	+/-0.010	10.066	*			
9.000	+/-0.005	8.994	*			
1.000	+/-0.005	.998	*			
0.260	+/-0.010	.258	*			
0.900	+/-0.010	.899	*			
R0.25	+/-0.030	.25	*			
R0.50	+/-0.030	.50	*			
5.000	+/-0.005	5.002	*			
0.875	+/-0.005	.875	*			
1.300	+/-0.010	1.305	*			
12.000	+/-0.005	11.998	*			
3.500	+/-0.005	3.495	*			
0.875	+/-0.005	.876	*			
R0.13	+/-0.030	.13	*			
0.500	+/-0.005	.501	*			
0.525	+/-0.005	.527	*			
1.80	+/-0.030	1.798	*			
Ø0.128	+0.005/-0.000	.130	*			
Ø0.377	+0.005/-0.000	.381	*			
Ø0.098	+0.005/-0.000	.102	*			
0.063 thick	+/-0.005	.061	*			
Grain Direction	N/A		*			

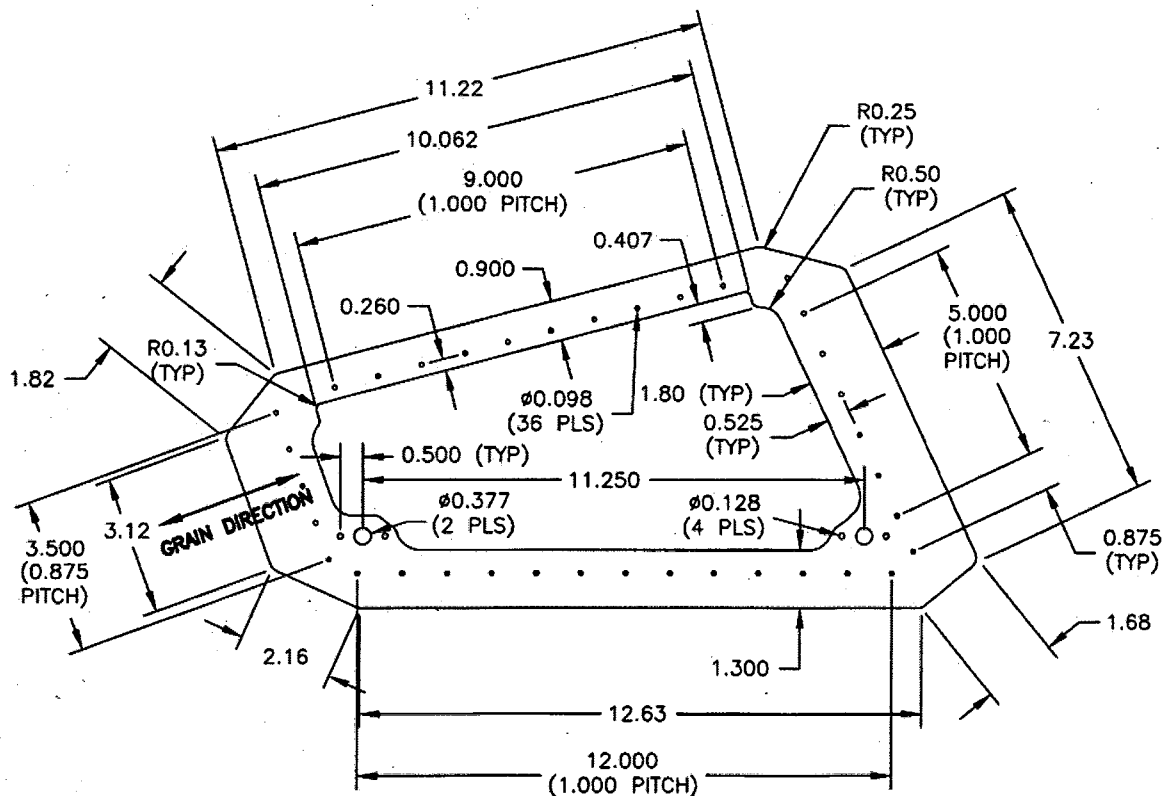
Measured by: ID	Audited by: S	Prototype Approval:	N/A
Date: 8-12-9	Date: 08/10/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.25	New Issue	KJ/JLM	



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3259	REV. A SHEET 4 OF 6
DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.14 *[Signature]*



D3259-3/-4 DOUBLER FLAT PATTERN
($\phi 0.098$ HOLES TO COINCIDE WITH HOLES IN D3259-1)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *43713*

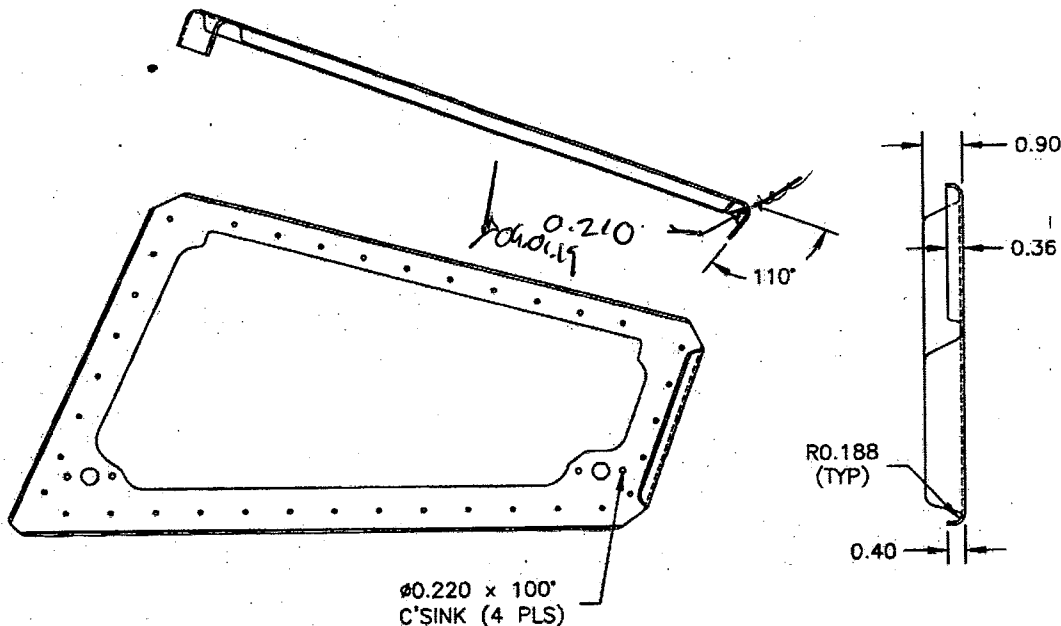
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3259	REV. A SHEET 3 OF 6
DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.14



D3259-3 DOUBLER BEND DETAIL (SHOWN)

BEND D3259-4 DOUBLER (OPPOSITE)

D3259-3/-4 NOTES:

- 1) MANUFACTURE PER "D2359-A4.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43772

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.